

Date: Saturday, 11/19/2005 10:45:26 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: FLOAT SKIDTUBE ASSEMBLY
<b>Job Number</b>	: 24802A		
<b>Estimate Number</b>	: 10309		
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: D206642541
<b>This Issue</b>	: 11/19/2005	<b>S.O. No.</b>	: N/A
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3274 REV C
<b>First Issue</b>	: N/A	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 24801A	<b>Drawing Revision</b>	: C
	<b>Type</b> : LANDING GEAR	<b>Material</b>	:
<b>Written By</b>	: <u>SEE COMMENT BELOW</u>	<b>Due Date</b>	: 12/20/2005
<b>Checked &amp; Approved By</b>	: <u>SEE ABOVE USER &amp; DATE</u>	<b>Qty:</b>	1
<b>Comment</b>	: Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM	<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D26001240	Extrusion Round 3" 206
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
 Pick:

Qty Part Number Description Batch

1 D2600-1-240 3" OD Tube B10427 DP05-11-23 ①

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-1 to 190.00" in length as per Dwg D3274 and Deburr ends

DP05-11-23

2-Drill #40 Aft cap pilot hole using DT8025

DP05-11-23

3-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

DP05-11-23

4-Remove inner indexing ridge on aft end of skidtube as per Dwg D3274

DP05-11-24

5-Open aft end cap holes to Ø.208" as per Dwg D3274. Deburr aft end.

DP05-11-24 ①

6-Open Ø.313" crossbolt spacer holes using DT8743 as per Dwg D3274

Pm 05-11-28

7-Open Ø.375" crossbolt spacer holes using DT8744 as per Dwg D3274

Pm 05-11-28

8-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

Pm 05-11-28

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.1

AM 05-11-24

①

4.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-01-03

①

5.0

D3282041

I-Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web

B 24862 am 06-01-16

①

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291

M 19134

Sikaflex expire date:

06-06-20

am 06-01-16

06-01-16

Start: ~~11:30~~

Time: 11:30

Finish: 06-01-23

Time: 2:30

a.m 06-01-23

(Adhere for 12 hours)

←

①

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JP 06-1-22 ①

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend tube using program D3274 as per Dwg D3274. Install drop pins in cross bolt spacer holes to maintain web position.

DP 06-1-23 ①

2-Cut Fwd end of tube to length as per Dwg D3274

DP 06-1-23

3-Remove inner indexing ridge on Fwd end of skidtube as per Dwg D3274

BE 06-1-24 ①

W/O:		WORK ORDER CHANGES					
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Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Drill pilot holes for wearplates using D3274-1T2, then open to  $\varnothing 0.25$ " (without cutting fluid)

BE 06-01-24 (1)

5-Deburr

BE 06-01-24 (1)

6-Counter sink cross bolt holes as per Dwg D3274

DP 06-1-24 (1)

9.0

D32851

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3285-1 Fwd Cap

B21744 BE 06-1-26 (1)

10.0

D2649

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D2649 Crossbolt spacer

B24200 BE 06-1-26 (1)

11.0

D32751

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D3275-1 Crossbolt spacer

B24861 BE 06-1-26 (1)

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D3274 and QSI 004. Use aluminum rod.

A/R Aluminum Rod M15855 / M19100 BE 06-1-26 (1)

2-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod M15855 BE 06-1-26 (1)

3-Grind welds flush to Fwd cap on top surface only.

BE 06-01-31 (1)

4-Grind cross bolt welds flush as per Dwg D3274. Masking Tape access to inside of the skidtube

BE 06-01-31 (1)

5-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

M 06-02-02 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
0603-01	B.4	hole size is .257 AS per dwg. // Change	E	06.03.01			 0603-01

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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06-02-05	B.6	Wearplate holes oversized due to improper C'sink method.	 06-02-05	re-work AS per W/O 26005. NCR 023. See attached sheets.	BE 06-03-01	 06-03-01		 060205

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Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and Counterbore. Inspect for foreign objects as per QSI 024

0603-01 PD 06-02-02

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q. m 06-03-16

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041 Nut Plate 824251

FC ①

17.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivet M14651

FC ①

18.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CR3212-4-03 Rivet M15918

FC 06 03 16

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 24802A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D26483

Wearpad



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 D2648-3 Wearpad B 24843

FL ①

20.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-15 Wearshoe B 9984

FL ①

21.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-23 Wearshoe B 22085

FL ①

22.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-35 Wearshoe B 24148

FL ①

23.0

D32871

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3287-1 Wearshoe B 22098

FL ①

24.0

D34291

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3429-1 Wearpad B 24417

FL 0.6 03 16  
①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 24802A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN960C10L

Inventory



Comment: Qty.: 78.0000 Each(s)/Unit Total: 78.0000 Each(s)

Pick:

Qty Part Number

Description Batch

78 AN960C10L

Washer m18822

FC ①

26.0

MS27039C108

SCREW



Comment: Qty.: 78.0000 Each(s)/Unit Total: 78.0000 Each(s)

Pick:

Qty Part Number

Description Batch

78 MS27039C1-08Screw

m19185

FC ①

27.0

NAS1330C3KB116

Insert



Comment: Qty.: 78.0000 Each(s)/Unit Total: 78.0000 Each(s)

Pick:

Qty Part Number

Description Batch

78 NAS1330C3KB116 Inserts

m190141

FC ①

28.0

NAS1515H3L

WASHER



Comment: Qty.: 78.0000 Each(s)/Unit Total: 78.0000 Each(s)

Pick:

Qty Part Number

Description Batch

78 NAS1515H3L Washer

m19185

FC 06 03 16 ①

29.0

D34131

RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3413-1

Ring m24222

FC 06 03 30 ①

30.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN4C5A

Bolt m18918

FC 06 03 30 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 24802A

Part Number: D206642541

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0	AN960C416L	Inventory
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN960C416L	Washer	m19822

FC ①

32.0	NAS1515H4L	Inventory
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	NAS1515H4L	Washer	m19099

FC ①

33.0	D2646	Aft Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	0233703

FC ①

34.0	AN960C10L	Inventory
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	m18822

FC ①

35.0	MS27039C108	SCREW
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
12	MS27039C1-08Screw		m19185

FC ①

36.0	NAS1515H3L	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	m19185

FC 06 03 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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37.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/RN/ALPS-3 m17395

FC

2-Install inserts & wearpads as per Dwg D3274. Use a drop of Sikaflex inside insert holes and a layer of sikaflex between wearplates and skidtube.

A/R Sikaflex-291 m14597

Sikaflex expire date: 06 18 06

FC

3-Install ring as per Dwg D3274

A/R Sikaflex-291 m14597

Sikaflex expire date: 06 18 06

FC

4-Inspect for foreign objects as per QSI 024

FC

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291 m14597

Sikaflex expire date: 06 18 06

FC

06 03 30

(1)

38.0

QC5

INSPECT WORK TO CURRENT-STEP



Comment: INSPECT WORK TO CURRENT STEP

mm

06/04/04

(1)

39.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(1)

06/04/10

Job Completion



W 06/04/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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